

Work Order ID 143522

Tuesday, March 15, 2016 11:22:36 AM

143522

Page 1

Item ID: D5393-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly
 Start Date: 3/28/2016 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 4/1/2016 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 163.15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5393	A								
100		0.00							
100									
Small Fab	Memo	0.02							
Small Fab	ASSEMBLE AS PER DWG AND TORQUE NUTS AS PER NOTE 8.								
						3	FF		MAR 31 2016
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
									DAS 38 MAR 31 2016
120	Identify as per dwg & Stock Location: <u><i>St</i></u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									
						3			DAS 3 MAR 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 143522

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143522

Page 2

Item ID: D5393-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Assembly
Start Date: 3/28/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 4/1/2016 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.01							
Quality Control									

ML5 APR 05 2016

ML5 ~~APR 04 2016~~

APR 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 143522

143522

Parent Item: D5393-041

D5393-041

Parent Item Name: Strut Assembly

Start Date: 3/28/2016

Required Date: 4/1/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 16.02.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6 *D2690-6* Lanyard		Manufactured	No				Each	8.0000		6 DAS 30 9-89			MAR 17 2016
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		8							
					140803	8				6			
D5393-043 *D5393-043* Strut Weldment		Manufactured	No				Each	0.0000		3 DAS 30 9-89			MAR 17 2016
AN3C3A *AN3C3A* Bolt		Purchased	No				Each	297.0000		6 DAS 30 9-89			MAR 17 2016
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		73							
				m132930		1							
				m134055		72				6			
				ST350		224							
				m133990		24							
				m134257		100							
				m134370		100							
MS17984-C405 *MS17984-C405* Pin, Quick Release		Purchased	No				Each	4.0000		6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST315		4							
				m134055		4				4			
										DAS 30 9-89			MAR 30 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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							Lead hand / Supervisor Approval Verification		
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Page 2

Work Order ID: 143522

143522

Parent Item: D5393-041

D5393-041

Parent Item Name: Strut Assembly

Start Date: 3/28/2016

Required Date: 4/1/2016

Start Qty: 3.00

Required Qty: 3.00

MS21043-3

Purchased

No

Each

911.0000

DAS
30
9-89

MS21043-3

Nut

**

MAR 17 2016

Location

Loc Qty

Loc Code

FG 80

103691 80

FP001 11

m130673 11

GA 33

m130673 15

m131677 18

OVER007 400

m133990 400

ST302 260

m133577 260

ST304 106

m131340 106

ST308 21

m132551 21

MS21919WCF8

Purchased

No

Each

2.0000

DAS
30
9-89

MS21919WCF8

Clamp

**

MAR 30 2016

Location

Loc Qty

Loc Code

ST291 2

M129947 2

1134513

(4)

2

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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		OTHER : ☐							

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Page 3

Work Order ID: 143522

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Parent Item: D5393-041

D5393-041

Parent Item Name: Strut Assembly

Start Date: 3/28/2016

Required Date: 4/1/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149C0332R

Purchased

No

Each

4,273.000

~~DAS~~
~~30~~
~~9.89~~

NAS1149C0332R

MAR 17 2016

WASHER

Location

Loc Qty

Loc Code

FP001

3062

m132262

4

m132930

1004

m134063

1838

m134073

216

GA

32

m133284

32

ST266

1179

m133284

679

m134474

500

12

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Shop Packet Print

Page 3

DQA: _____ Date: _____



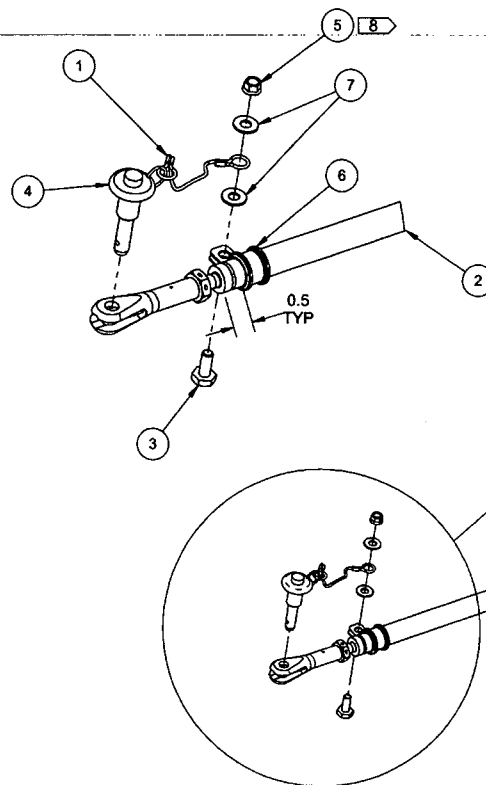
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OTHER : ☐					

**DETAIL A
(TYP)**



D5393-041 STRUT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.76 lbs
- 8) TORQUE NUTS TO 20-25 in-lb

Handwritten: 16-3-15
143522

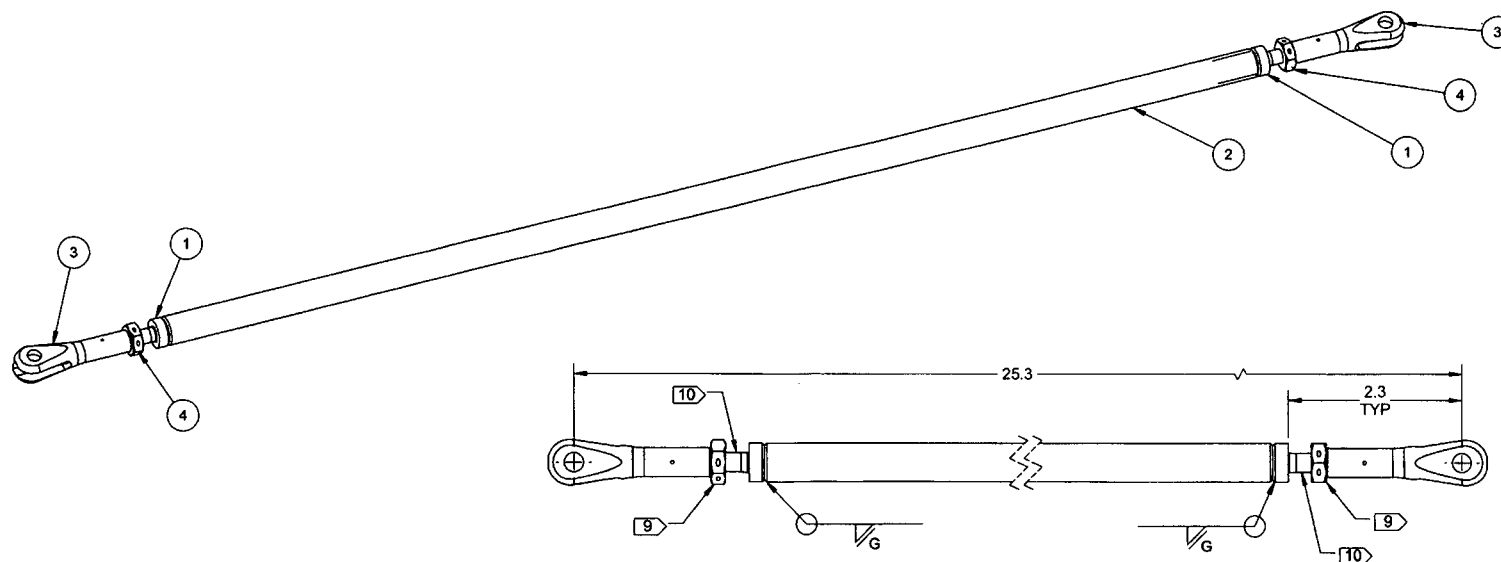
RELEASED
2016-02-08
EN16-520

APPROVED

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5393-041	STRUT ASSEMBLY
1	2	D2690-6	LANYARD ASSEMBLY
2	1	D5393-043	STRUT WELDMENT
3	2	AN3C3A	BOLT
4	2	MS17984-C405	PIN, QUICK RELEASE
5	2	MS21043-3	NUT, SELF-LOCKING
6	2	MS21919WCF8	CLAMP
7	4	NAS1149C0332R	WASHER

A	NEW ISSUE	RF	16.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5393	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D5393-043	STRUT WELDMENT
1	2	D4794-3	STUD
2	1	D5393-1	STRUT
3	2	AN665-34R	THREADED CLEVIS
4	2	NAS509-4C	NUT, JAM



D5393-043 STRUT WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.62 lbs
- 8) WELD PER DART QSI 004
- 9) HAND TIGHTEN NAS509-4C NUT
- 10) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

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2016-02-08

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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5393	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
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0.030 x 45°
CMF, 2 PL

Ø

20.40

Ø0.500
REF

0.049
REF

D5393-1 STRUT

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM S269
REF. DART SPEC M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs

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2016-02-08

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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5393	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
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